

Work Order ID 125508

125508

Complete.

Thursday, October 09, 2014 2:19:54 PM

Page 1

Item ID: 41228-202-136-001 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Bkt./Thermistor Lead Assy
 Start Date: 10/9/2014 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 10/9/2014 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: NLS Date: 14-10-09 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
41228-202-136	A1								
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	MANUFACTURE AS PER DWG'S								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>CA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									

2 0 KC
14/09/30

① 15-02-02 DAS
9
9-89

② KC
14/09/30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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125508

Page 2

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Revision ID: Stop ***NS2***
Item Name: Mounting Bkt./Thermistor Lead Assy
Start Date: 10/9/2014 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 10/9/2014 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ML5 1502-10

149-30

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Training									
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Unapproved									

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Picklist Print

Thursday, October 09, 2014 2:19:59 PM

Page 1

Work Order ID: 125508

125508

Parent Item: 41228-202-136-001

41228-202-136-001

Parent Item Name: Mounting Bkt./Thermistor Lead Assy

Start Date: 10/9/2014

Required Date: 10/9/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.07.31 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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NAS1149DN432J

Purchased

No

Each

320.0000

4

NAS1149DN432J

WASHER

KC
14/09/30

Location

Loc Qty

Loc Code

CA

138

m129682

138

4

ST277

182

m127832

100

m129022

82

MS21042L04

Purchased

No

Each

96.0000

2

MS21042L04

NUT

KC
14/09/30

Location

Loc Qty

Loc Code

CA

18

M129682

18

2

ST307

78

125653

78

MS35206-216

Purchased

No

Each

89.0000

2

MS35206-216

SCREW

KC
14/09/30

Location

Loc Qty

Loc Code

CA

89

M129682

89

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 125508

125508

Parent Item: 41228-202-136-001

41228-202-136-001

Parent Item Name: Mounting Bkt./Thermistor Lead Assy

Start Date: 10/9/2014

Required Date: 10/9/2014

Start Qty: 2.00

Required Qty: 2.00

41228-202-090-001

Manufactured No

Each

11.0000

2

41228-202-090-001

412 Mounting Bracket

KC
14/09/30

Location

Loc Qty

Loc Code

CA

11

m129682

11

2

41228-400-010-001

Manufactured No

Each

13.0000

2

41228-400-010-001

412 Thermistor Harness Assembly

KC
14/09/30

Location

Loc Qty

Loc Code

CA

13

m129682

13

2

DQA: _____ Date: _____



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APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTIC NO. 01928				SHEET 1 OF 1	
DWG NO. 41228-202-136		REV: A	PREPARED BY D. BARKER	DATE: 08/29/07	EFFECT ON DWG ☐ INC. ☒ UNINC.
DWG TITLE: MOUNTING BRACKET & THERMISTOR LEAD ASSY					
APPROVED BY: ENGR	MFG		QC	EFF: CURRENT ORDER	
REASON: UPDATED PARTS LIST					

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

SHEET 1, PARTS LIST IS:

IS

A

AR	CB-200	ACRYLIC ADHESIVE CARSON CITY, NV.				
1	MS21042L04					
2	AN960JD4					
1	MS35206-216					
1	41228-400-010-001	LEAD ASSY				
	41228-202-090-001	BRACKET ASSY				
	41228-202-136-001	ASSY				
-001	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC.	ZONE
NO. REQ'D PER ASSY.		LIST OF MATERIAL				
PROPRIETARY RIGHTS NOTICE		UNLESS OTHERWISE SPECIFIED	ORFTSM	T. HARVILLE	8/25/94	TITLE
THESE DATA ARE PROPRIETARY TO ERA AMATION, INC. INCLUDING REPRODUCTION OR USE OF THESE DATA FOR ANY PURPOSE IS PROHIBITED WITHOUT AUTHORIZATION FROM ERA AMATION, INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.		X ± .1	CHECK			MOUNTING BRACKET & THERMISTOR LEAD ASSY
		XX ± .03	STRESS			
		XXX ± .010	PROA			
		ANGLES ±	ENGR			
			HEAT TREAT			
			FINISH			
-001	2	41228-202-133	Era Helicopters LLC		DWG. NO. 41228-202-136	REV. A
DASH NO.		REV'D FOR ASSY	SCALE		C	NONE
NEXT ASSEMBLY						

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 125508 MLS
1410-09

**CONTROL COPY
ISSUED DATE
SEP 04 2007**

F/N	TC	PART NUMBER	QTY	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE
DOCUMENTS EFFECTED:					CHANGE CATEGORY		DER REVIEW REQUIRED	
☐ MDL ☐ INSTALL INSTRU ☐ ICA ☒ BOM					☐ MAJOR ☒ MINOR		☐ YES ☒ NO	

DQA: _____ Date: _____



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REVISION				APPROVED DATE	
LETTER	DFTSMAN	DATE	DESCRIPTION		
A	DNN	6/13/05	INCRP. E.O. A-1: CHG. 41228-202-090-003 BRACKET TO 41228-202-090-001 BRACKET ASSY ON L/M. MINOR CHANGE - FAR 21.95		

41228-202-090-001
BRACKET ASSY

41228-400-010-001
THERMISTOR LEAD ASSY

MS35206-216 SCREW (1)
AN960JD4 WASHER (4)
MS21042L04 NUT (1)

UNINCORPORATED ECN(s)

01928

				AR	CB-200	ACRYLIC ADHESIVE CARSON CITY, NV.					
				1	MS21042L04						
				2	AN960JD4						
				1	MS35206-216						
				2	41228-400-010-001	LEAD ASSY					
				1	41228-202-090-001	BRACKET ASSY					
					41228-202-136-001	ASSY					
				-001	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL. SPEC.	ZONE	
NO. REQ'D PER ASSY.											
LIST OF MATERIAL											
TITLE											
MOUNTING BRACKET & THERMISTOR LEAD ASSY											
DWC. SIZE C SCALE NONE											
DWC. NO.											
41228-202-136											
Era Helicopters LLC											

△ ATTACH LEAD ASSY TO BRACKET IN POSITION AS SHOWN USING
CLICK BOND ADHESIVE & HARDWARE LISTED.

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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